/	Order ID	68570
ay, A	pril 18, 2011	11:32:42 AM
em ID:	D3204-	041



Page 1

Revision ID:	D3204-041 Release Pedal Assembly		Accept			Set	ıp Start Stop	
	4/18/2011 Start Q			Cust Item II Customer:	D:		•]
Approvals:	Process Plan:(QC:	Date:///	Tooling: SPC (Y/N):	Da		Run	Start Stop	
Sequence ID/ Work Center II	Operation Descript		Set Up/ Run Hours	Tool ID	Tool # Plan Code	-		eject Insp. lumber Stamp
Draw Nbr	Revision Nbr				1411		· · · ·	
D3204	Rev A1							
00 Large Fab	Large Fab	Memo	0.00			a	11-8-	7 (6
arge Fab		1- Weld assembly as per Dwg diameter hole in the center of	D3204 using Jig D3204-041T1. ©0.760" c'bore on D3204-5 arm pr gg the hole after assembly. 14- Grit 1/4703.	ior to weld. □3-				
	QC9- Inspi	ect visual per QS1004- Fusion V	velds 0.00			11.8	78.0	3 6
QC Quality Control	·	Memo	0.00		'		<u> </u>	
20	QC5- Insp	ect part completeness to step on	Sulo	50/30		6		
QC Quality Control		Memo	0.00					W-1

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector			
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		ž.											
Part No:		PAR #:	Fault Cate	gory:	_ NCR: `	es N	10 DQ	A:	Date: _				
	Reso	olution:	tion: QA: N/C Closed: Date:										
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DATE	STEP	Description of NC			tion B		Verifi	cation	Approvai	Approval			
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Sect	ion C	Chief Eng	QC Inspecto			
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Work Order ID 68570

Monday, April 18, 2011 11:32:42 AM



Page 2

Item ID:

D3204-041

Accept



Setup Start



Revision ID:

Item Name:

Required Date: 4/21/2011

Release Pedal Assembly

Start Date:

4/18/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Run

Start

Stop

Stop



Date:

SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject

Insp. Number Stamp

Sequence ID/ **Work Center ID**

130

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Set Up/

Run Hours

140

Powdercoat

Powder Coating

1117338

Memo

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

Cover holes for bushing

START TIME:

10. 300
OVEN TEMPERATURE:

12. 02

OFINISH

TIME:

3709

150

Memo

QC3- Inspect Part Finish

0.00

0.00

6x & Mf 4/08/03

Quality Control

W/O:		WORK ORDER CHANGES													
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
Part No):	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA: _	Date: _								
	Re	esolution:	Dispositio	n:	_ QA: N/C C	osed:	Date: _								
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DATE	STEP	Description of NC			ion B	Verification		Approval							
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		Chief Eng	QC Inspector							
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Work Ord Monday, April												Page 3
Item ID: Revision ID:	D3204-041			Accept					Setup	Start		•
Item Name:	Release Pedal	Assembly								Stop		
Start Date:	4/18/2011	Start Qty: 4.00			Cust Item 1	D:						
Required Date: Reference:	4/21/2011	Req'd Qty: 4.00			Customer:							
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:]	Run	Start		
	QC:		Date:	SPC (Y/N):	D:	ate:				Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
		Small Fab		0.00				R	/	/_~	1.	
Small Fab		Memo		0.00				7	[[_	08	107	-6
Small Fab		Install D320	4-7 bushing as shown in D	wg D3204								
170 		QC5- Inspect part comple	eteness to step on W/O	0.00	i							
QC Quality Control		Memo		0.00 کے ہا	oslog			(F6)	—		44.86	
180 Packaging		Identify as per dwg & Sto	ock Location: 6.A	0.00				S	<u> /0</u>	/ 18/.	12(1	5)

Packaging

W/O:	<u>.</u>		\\/(ORK ORDER CHANG	EC		 					
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NCR:	:	V	VORK ORD	ER NON-CONFORM	ANCE (NC	R)						
DATE	STEP	Description of NC			tion B		cation	Approval	Approval			
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector			
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Work Ord Monday, April												Page
Item ID: Revision ID:	D3204-041			Accept					Setup	Start	11001110101	
Item Name: Start Date: Required Date:	Release Peda 4/18/2011 4/21/2011	Start Qty: 4.00 Req'd Qty: 4.00	10 5 10 15 15 15		Cust Item I Customer:	D:				Stop		
Reference:			110011110111111111111111111111111111111									
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	_	
Sequence ID/ Work Center II	D	Operation Description QC21- Final Inspection	. Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp

0.00

Memo

Quality Control

W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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•	Re	solution:	Dispositi	on:	QA: N	/C Clo	sed:		Date: _	
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC			ction B	» o	Verification		Approval	Approval
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Picklist Print

Monday, April 18, 2011 11:32:49 AM

Work Order ID: 68570

D3204-041

Parent Item Name: Release Pedal Assembly

Parent Item:



Start Date: 4/18/2011

Start Qty: 4.00

Required Date: 4/21/2011

Page 1

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1	II III	Manufactured	No			100	Each	2.0000	1	4 	11-8-	<u>م</u>	
	6857	1 14		Location WA019	60883	<u>Loc (</u>	2 2 2	Loc Code	_	~	_		
03204-11 		Manufactured	No			100	Each	36.0000		4 EZ	11-8-2	> -	
				WA019	57522 55463	<u>Loc (</u>	14 14 22 22	Loc Code	<u>-</u>		 		
03204-3		Manufactured	No		33403	100	Each	7.0000	1	4	11-8-	2	
	70317	×4		Location WA019		<u>Loc (</u>	<u>Oty</u> 7 1	Loc Code	-		_		
03204-5 		Manufactured	No			100	Each	6.0000	1	4 EZ	/1-8	·->	
	70)320 X	(6	<u>Location</u> WA	65140	Loc	<mark>Otv</mark> 6 6	Loc Code	_		_ _		

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W/O:			W	ORK ORDER CHANG	GES					
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Part No		PAR #:		egory:		R: Yes	No DQ	A:	Date:	
	Res	olution:	Disposition	on:	QA:	N/C Clo	sed;		Date:	
NCR:			WORK ORE	DER NON-CONFORM	ANCE	(NCR)			
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Picklist Print

Monday, April 18, 2011 11:32:49 AM

Work Order ID: 68570

Parent Item:

D3204-041

Parent Item Name:

Release Pedal Assembly





60871

65141

Start Date: 4/18/2011

Required Date: 4/21/2011

Page 2

Start Qty: 4.00

Required Qty: 4.00

D3204-7

Bushing

D3204-9

Pedal

6088413 68573 x 3

Manufactured

Manufactured

D3204-13

Gusset

Manufactured No 100

Each

13.0000

Loc Oty Loc Code 13 13 100 Each 4.0000

Loc Qty Loc Code

160 Each 12.0000

Location WA019

Location

Location

WA

ST041

No

Loc Qty 12

12

Loc Code

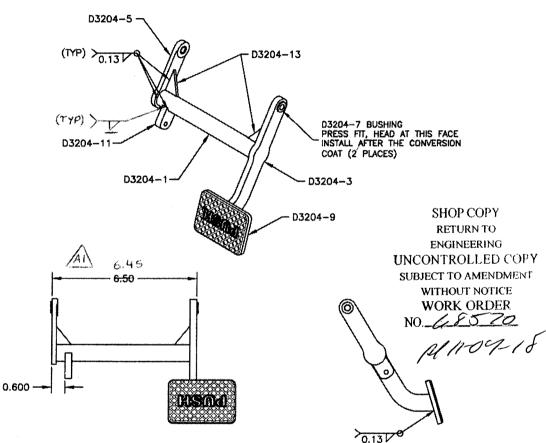
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DC	QA:	Date: _	
	Re	solution:	Disposit	ion:	_ QA: N/C (Closed:	·	Date: _	
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05.07.15 6.45 WAS 6.50



D3204-041 RELEASE PEDAL ASSEMBLY

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125) 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010 WELD ASSEMBLY PER QSI 004

- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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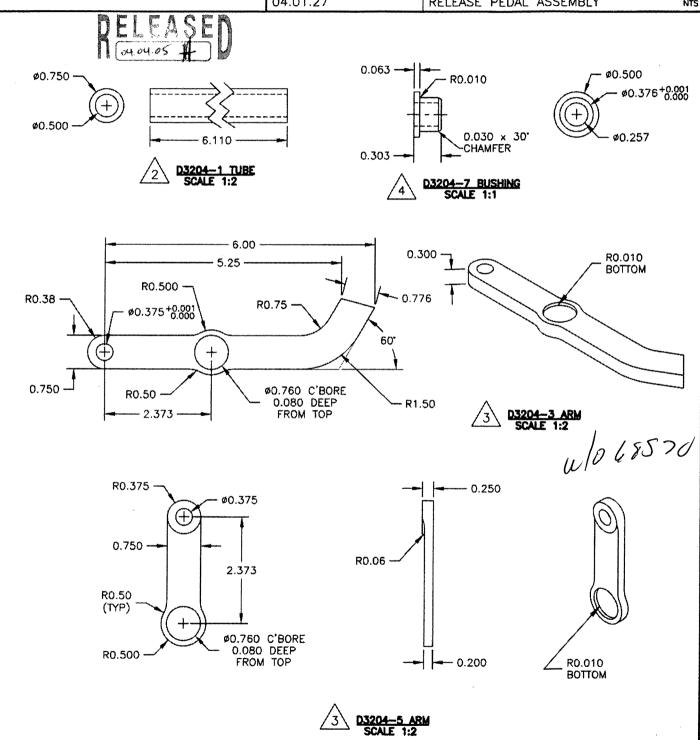
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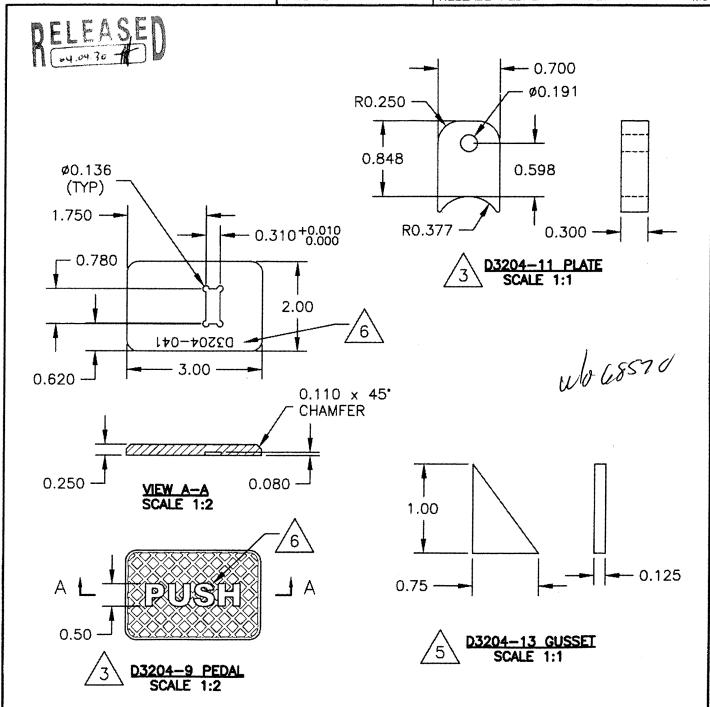
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